

**Work Order ID 53199**

Page 1

October 26, 2009 12:40:54 PM

Item ID: D2221

Accept



Setup Start



Revision ID: H

Stop



Item Name: 350 Basket Base

Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: PLDate: 09.10.20

Tooling:

Date:

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2221	Rev H

100

0.00



Large Fab

Large Fab

Memo

0.00

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221  
 2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per  
 dwg D2221  
 3- tack weld mesh on basket as per dwg D2221  
 A/R ER316 S.S. Rod Batch: M109213

PL 09.10.30

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PL 09.11.02

**Work Order ID 53199**

Page 2

October 26, 2009 12:40:54 PM

Item ID: D2221

Accept



Setup Start



Revision ID: H

Stop



Item Name: 350 Basket Base

Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC6- Inspect dimensions to drawing

0.00

2) Sotula

QC

Quality Control

Memo

0.00

130

4 pressure wash  
White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

X1112248

M 09/11/03

Powdercoat

Powder Coating

Memo

0.00

1- Plug holes prior to

1ST COAT:

START TIME: 2:00 pm

OVEN TEMPERATURE: 400°F

FINISH TIME: 2:30 pm

\*\*\*\*\* 2nd coat if necessary \*\*\*\*\*

2ND COAT:

START TIME: 2:30 pm

OVEN TEMPERATURE: 400°F

FINISH TIME: 3:00 pm

**Work Order ID 53199**

Page 3

October 26, 2009 12:40:54 PM

Item ID: D2221

Accept



Setup Start



Revision ID: H

Stop



Item Name: 350 Basket Base

Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140



QC3- Inspect Part Finish

0.00

①

QC

Quality Control

150

Memo

0.00

PPR 52036

150160



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

**Picklist Print**

Page 1

October 26, 2009 12:40:59 PM

Work Order ID: 53199



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2221-1RevH 		Manufactured	No			100	Each	13.0000	1.0000		<i>apl 09.10.28</i>	

Rib

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Main Warehouse

ST

1

48101

1

Main Warehouse

WA

12

51872 ✓

12

D2221-5RevH



Rib

Manufactured

No

100 Each 2.0000 2.0000

*apl 09.10.28*

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Main Warehouse

ST

2

50026

2

*B53131 → (2) ✓*

D2221-7RevH



Rib

Manufactured

No

100 Each 5.0000 1.0000

*apl 09.10.28*

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Main Warehouse

WA

5

51090

1

51251 ✓

4

*(1)*

**Picklist Print**

Page 2

October 26, 2009 12:40:59 PM

Work Order ID: 53199



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2232-3RevC



Manufactured

No

100

Each

13.0000

2.0000



Cp 09.10.28

Basket Hinge

WarehouseLocation

Main Warehouse

ST

13

50024

51870 ✓

2

11

\_\_\_\_\_

D2235-1RevB1



Manufactured

No

100

Each

20.0000

2.0000



Basket Rib

WarehouseLocation

Main Warehouse

ST

7

51438 ✓

7

②

Main Warehouse

WA

13

50565

51871

3

10

\_\_\_\_\_

**Picklist Print**

Page 3

October 26, 2009 12:40:59 PM

Work Order ID: 53199



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
--------------------------------	---------------------	---------------	----------	------------------	---------------	--------------	-----------------	-------------	-----------------------	------------	-------------	--------

D2581RevA1



Manufactured

No

100

Each

66.0000

2.0000



Mounting Bracket

*Glo 10-28*WarehouseLocation

## Main Warehouse

ST

13

---

46086

2

---

48428

1

---

51120

10

---

## Main Warehouse

WA

53

---

50872

4

---

51745 ✓

49

---

D3442-1RevA



Manufactured

No

100

Each

18.0000

2.0000



Shim

*(2)*

---

*Glo 10.28*WarehouseLocation

## Main Warehouse

ST

1

---

46767

1

---

## Main Warehouse

WA

17

---

50951 ✓

17

---

*(2)*

# Picklist Print

Page 4

October 26, 2009 12:40:59 PM

Work Order ID: 53199



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3825-041RevA

Manufactured

No

100

Each

8.0000

2.0000

Rib Assembly (Basket End)



*Pd09.10.28*

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

51869 ✓

6

6

*(2)*

Main Warehouse

WA

51171

2

2

*\_\_\_\_\_*

D3826-041RevB

Manufactured

No

100

Each

8.0000

2.0000

Rib / Gusset Assembly



*Pd09.10.28*

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

51340 ✓

6

6

*(2)*

Main Warehouse

WA

51088

2

2

*\_\_\_\_\_*

# Picklist Print

Page 5

October 26, 2009 12:40:59 PM

Work Order ID: 53199



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3827-041RevA



Manufactured

No

100

Each

5.0000

1.0000



Pd 09.10.28

Rib Assembly (Inboard)

Warehouse                            Loc Qty                            Loc Code

Location

Main Warehouse

ST

51339

5

5

100    Each                                    6.0000                            1.0000

①

D3832-1RevA



Manufactured

No

100

Each

6.0000

1.0000



Pd 09.10.29

Mesh (Base)

Warehouse                            Loc Qty                            Loc Code

Location

Main Warehouse

ST

2

46306

1

46774

1

Main Warehouse

WA

4

50942

1

51863

3

①

**Picklist Print**

Page 6

October 26, 2009 12:40:59 PM

Work Order ID: 53199



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3833-1RevA



Manufactured

No

100

Each

10.0000

2.0000



Mesh (Base End Face)

*PL09-10-29*

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

51304 ✓

8

8

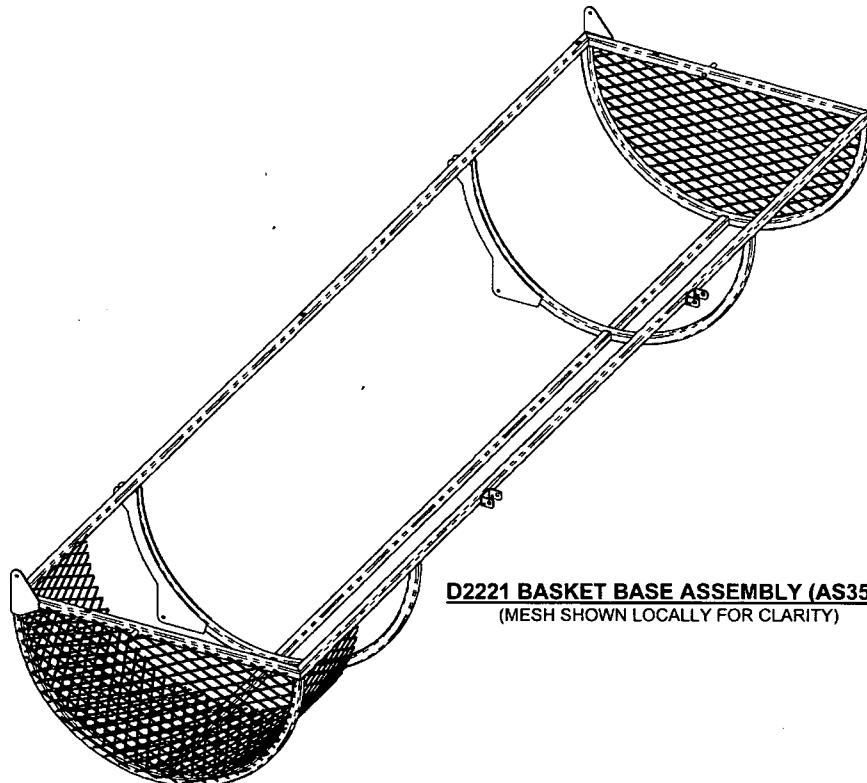
Main Warehouse

WA

50025

2

2



**D2221 BASKET BASE ASSEMBLY (AS350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASER  
08/11/18 N/A

SHOP COPY

RELEASER

ENGINEER

UNCONTROLLED

SUBJECT TO CHANGE

WITHOUT NOTICE

WORK OR LID

NO. 53199

180810-24

OTES:

MATERIAL: N/A

FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3

TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: 0.005 TO 0.010 MAX

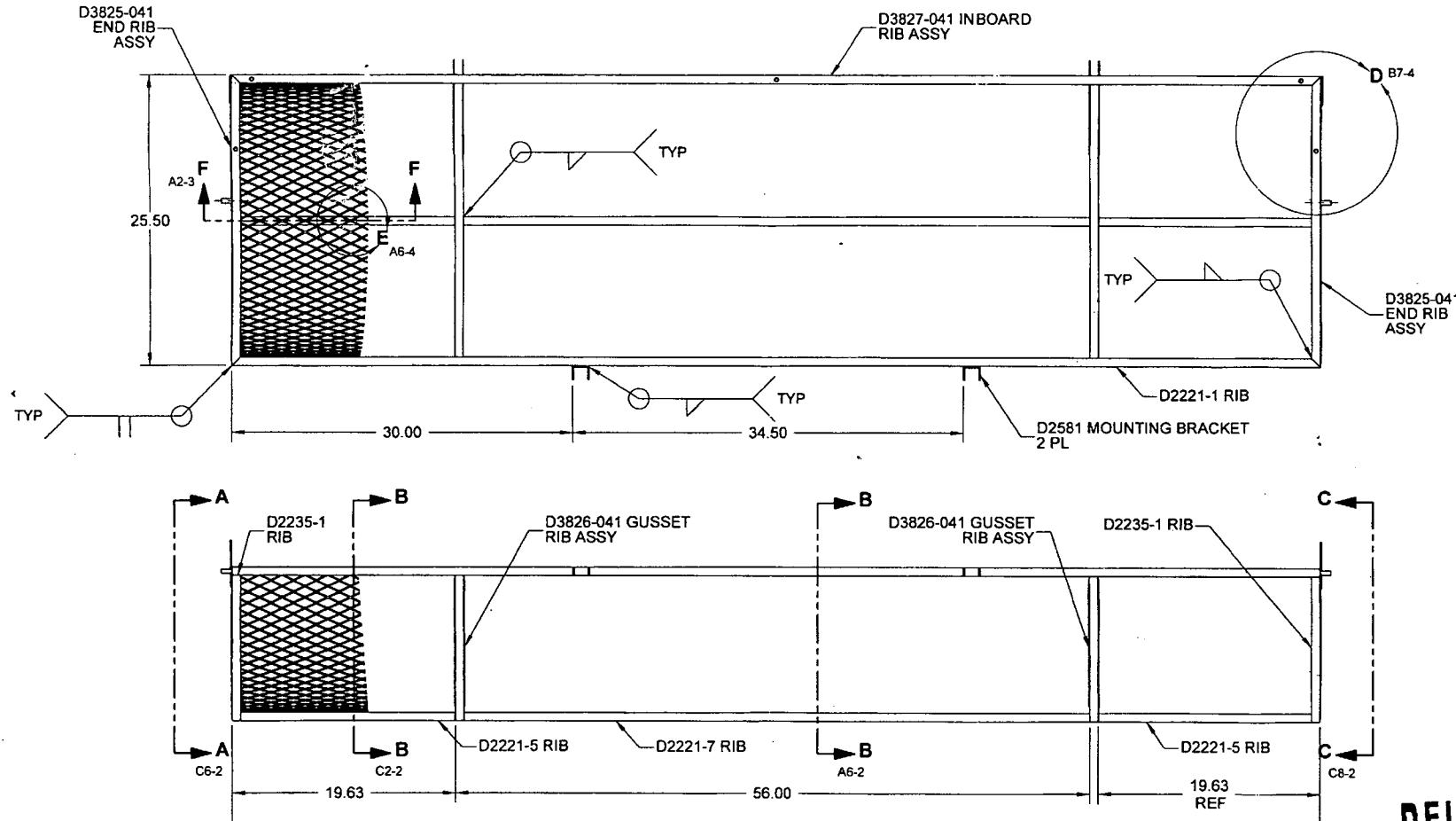
IDENTIFICATION: N/A

WEIGHT: 42.00 lbs APPROX

MASK ALL HOLES PRIOR TO POWDER COATING

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/5-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	WSS	DRAWING NO.	REV. H
MFG. APPR.	WSS	D2221	SHEET 1 OF 5
APPROVED	WSS	TITLE	SCALE
DE APPR.	WSS	BASKET BASE ASSEMBLY (350)	NTS
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**D2221 BASKET BASE ASSEMBLY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1	DRAWING NO. D2221	
MFG. APPR.	1	REV. H	
APPROVED	1	SHEET 2 OF 5	
DE APPR.	1	TITLE BASKET BASE ASSEMBLY (350) NTS	
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8

7

6

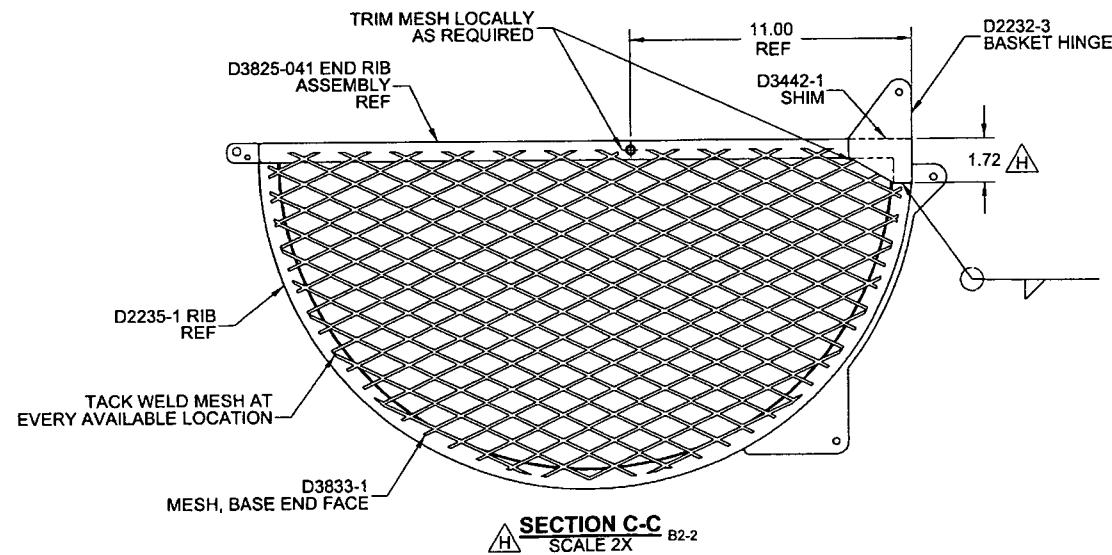
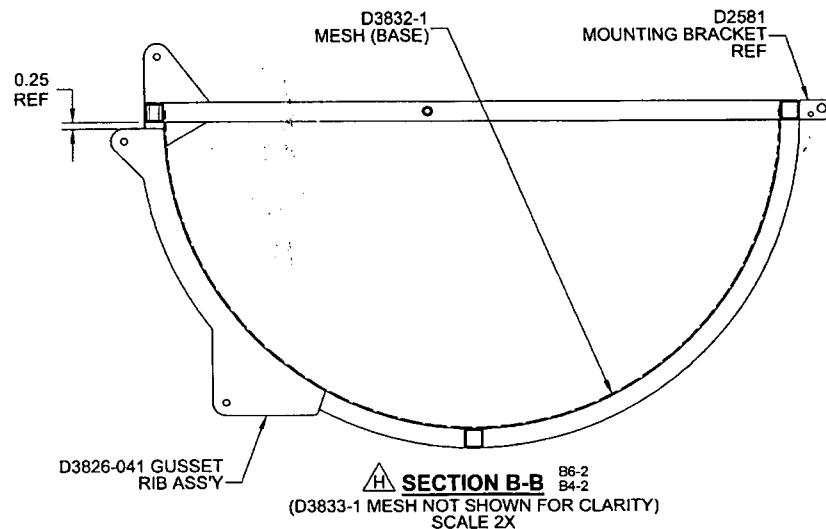
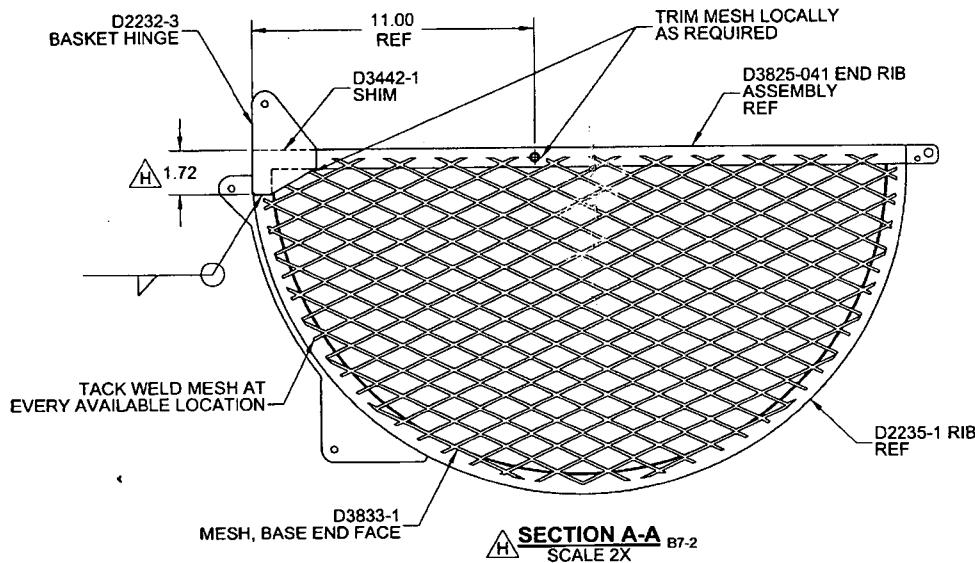
5

4

3

2

1



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WORK ORDER  
58199

RELEASE  
08/11/16 MWD

DESIGN	EW	DART AEROSPACE LTD	
DRAWN	✓	HAWKESBURY, ONTARIO, CANADA	
CHECKED	✓	DRAWING NO.	REV. H
MFG. APPR.	✓	D2221	SHEET 3 OF 5
APPROVED	✓	TITLE	SCALE
DE APPR.	✓	BASKET BASE ASSEMBLY (350) NTS	
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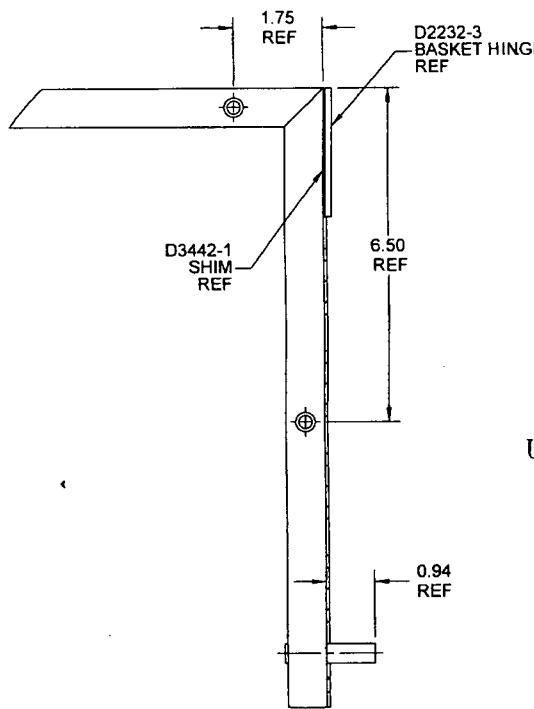
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4

3

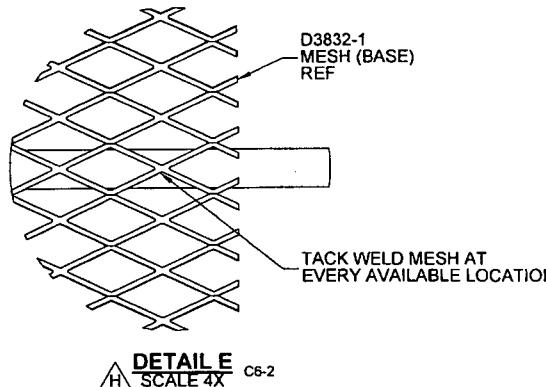
2

1

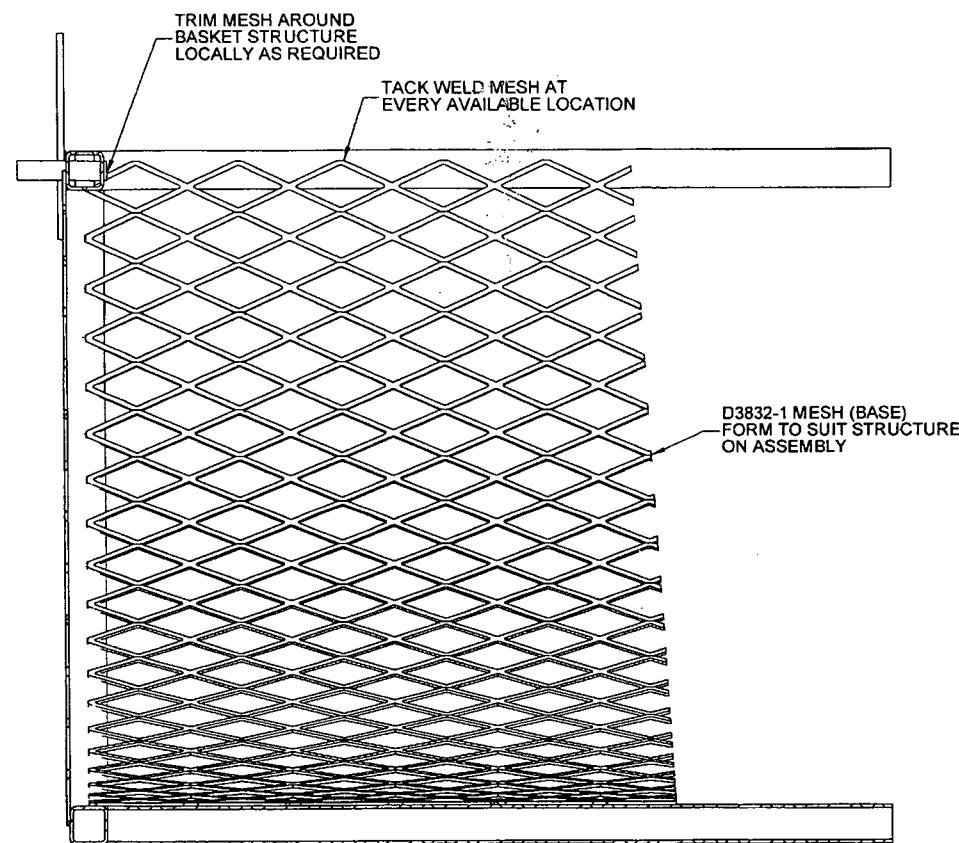


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WORK ORDER  
NO. 53199

⚠ **DETAIL D** D2-2  
SCALE 4X



⚠ **DETAIL E** C6-2  
SCALE 4X

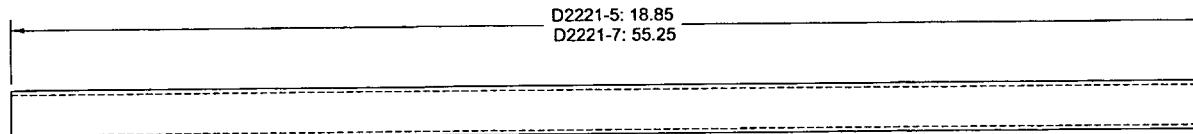
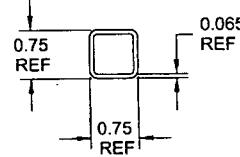
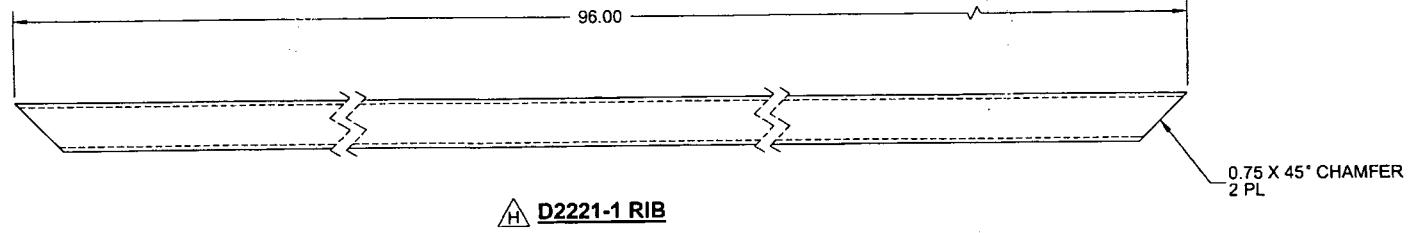
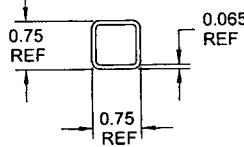


⚠ **SECTION F-F** D7-2  
SCALE 4X

RELEASED  
02/11/18 MD

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2221	
MFG. APPR.		REV. H	
APPROVED		SHEET 4 OF 5	
DE APPR.		TITLE SCALE	
DATE 08.09.18		BASKET BASE ASSEMBLY (350) NTS	

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 WITHOUT NOTICE  
 WORK OF AIR  
 NO. 53199

NOTES:  
 MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
 REF. DART SPEC. M304TS0.750W0.065  
 FINISH: NONE  
 TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 UNITS: INCHES UNLESS OTHERWISE NOTED  
 BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 IDENTIFICATION: N/A  
 WEIGHT: D2221-1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

RELEASED  
06/11/18 WD

DESIGN	BW	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	<u>ASS</u>	DRAWING NO. REV. H
MFG. APPR.	<u>WD</u>	D2221 SHEET 5 OF 5
APPROVED	<u>WD</u>	TITLE SCALE
DE APPR.	<u>WD</u>	BASKET BASE ASSEMBLY (350) NTS
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